

Date: Friday, 23/05/2008 12:41:39 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LABEL PLATE
Job Number : 39457	
Estimate Number : 10599	
P.O. Number :	Part Number : D2506
This Issue : 23/05/2008 S.O. No. :	Drawing Number : D2506 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 37446	Material :
Written By :	Due Date : 06/06/2008 Qty: 25 Um: Each
Checked & Approved By : <u>JUD 08.5.23</u>	
Comment : Est. B 01.06.08 Now laser cut EC est C 06.12.13 ecn 822 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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39



Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s)

304/316 .040 Sheet

Batch: 108156 B 8-5-28

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: EProg Rev: E

B 8-5-28

(30)

2-Deburr if necessary

B 8-5-28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-5-28

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

500/05/27 (30) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

Done at step # 22
 500/05/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 12:41:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 39457

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SB 08/06/03 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
08/06/05 (30)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT Duval

SS 08/06/05 (30)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/05
MF 08-06-05

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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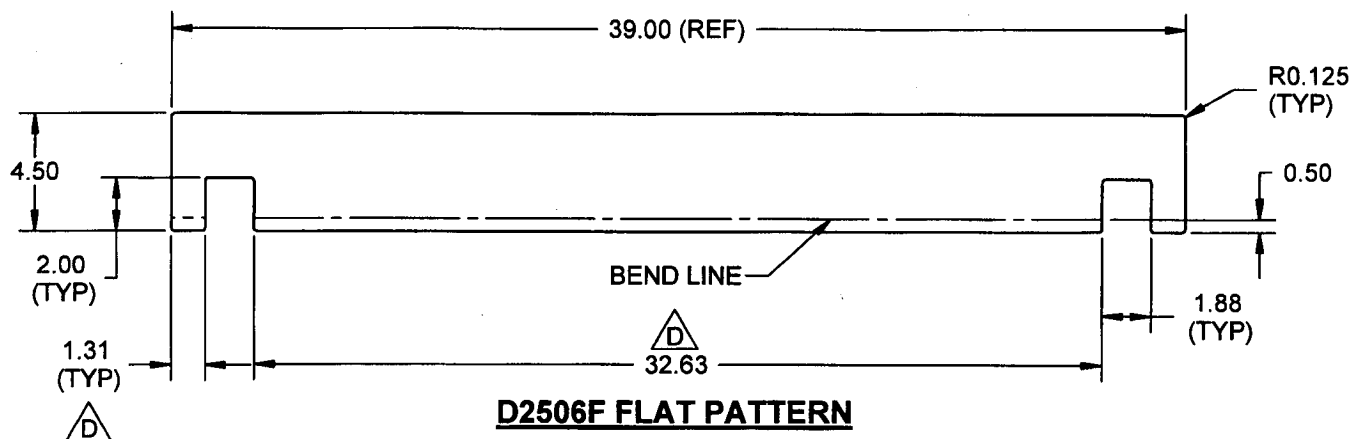
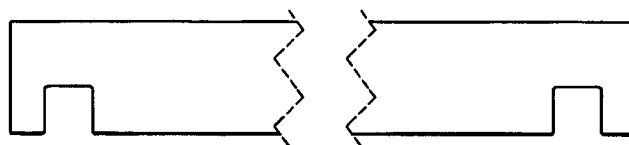
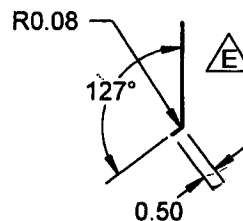
NOTE: Date & initial all entries

DART

RELEASED

06.11.28

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2506	REV. E SHEET 1 OF 1
DATE 06.11.20	TITLE LABEL PLATE		SCALE 1:7
REV	DATE	DESCRIPTION	
A	95.11.26	NEW ISSUE	
B	96.06.18	RE-DESIGN OF LABEL PLATE	
C	96.09.04	RE-DESIGN OF LABEL PLATE	
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50	
E	06.11.20	REMOVE 10° BEND; ADD NOTES; 127° WAS 126°	

**D2506F FLAT PATTERN****D2506 LABEL PLATE****NOTES:**

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019 (REF DART SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39457

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